

Date: Monday, 05/05/2008 11:11:54 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FIXTURE
Job Number : 39034	
Estimate Number : 13295	
P.O. Number :	Part Number : D37855
This Issue : 05/05/2008 S.O. No. :	Drawing Number : D3785 PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : R & D SM/MED FAB	Drawing Revision : PRELIM 08.05.27
Previous Run :	Material :
Written By : <u> </u>	Due Date : 08/05/2008 Qty: 2 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev:A 08-05-01 new issue DD verified by:EC	

Additional Product

FOR ENGINEERING USE ONLY **PRELIMINARY ISSUE**

PROTOTYPE

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

M304B0625X3000

304 BAR: 625 X 3.00

Comment: Qty.: 0.0137 f(s)/Unit Total: 0.0273 f(s)

304 BAR: 625 X 3.00

batch: 106859

IB 8-5-5

103755

IB 8-5-22

2.0

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3785

Dwg Rev: PRE-L.

Prog Rev: PRE-L.

2- Debur if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Face mill to finish size as per dwg D3785 08/05/22

2- open hole to finish size as per dwg D3785 08/05/21

3- tap hole as per dwg D3785

FF 08-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3785-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR: <u>39034</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/05/21</u>		Scrap due ^{to} material chg. S.S. to Alum. 6061T6	<u>[Signature]</u>	Scrap and destroy all parts <u>Redue with new</u> material chg	<u>[Signature]</u> <u>08/05/21</u>	<u>[Signature]</u> <u>0805-22</u>	<u>[Signature]</u> <u>0805-22</u>	<u>[Signature]</u> <u>08-05-22</u>
				- Replace on this w/o Qty 1 in 103755				

NOTE: Date & initial all entries

Date: Monday, 05/05/2008 11:11:54 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FIXTURE

Job Number: 39034

Part Number: D37855

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



08.05.14
(2)

Comment: INSPECT WORK TO CURRENT STEP

08/05/13 (42)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Quarantine

08/05/26 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27

08.06.01 Promypc
MF 08-05-27

Job Completion



00224A

POSITIVE RECALL

EFFECTIVE 08.05.05 AUTH 4

RELEASED 14 DATE 08.05.22

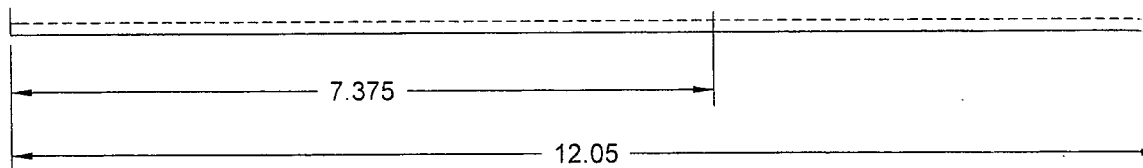
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

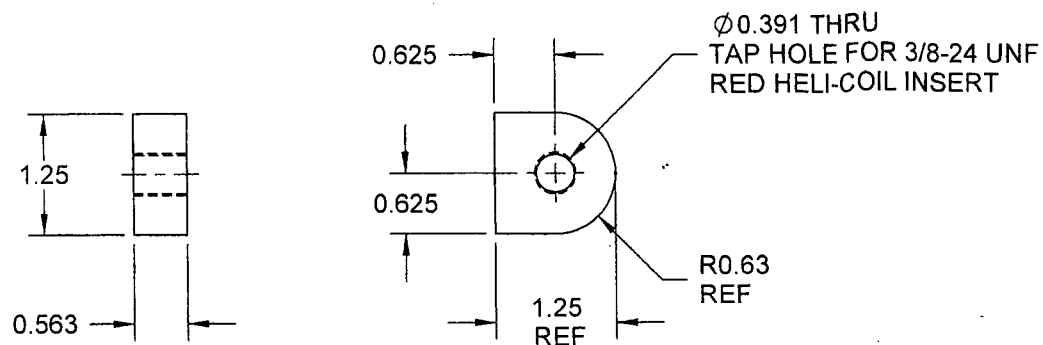
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3785-1 TUBE



D3785-5 FIXTURE

W/O 39034

PROTOTYPE

08.05.27

D3785-1/-5 NOTES:

1) MATERIAL:

- D3785-1: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING, 1.25 X 1.25 X 0.120 WALL, PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.250W.120)
- D3785-5: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (REF. DART SPEC. M6061T6B)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: - D3785-1 = 0.59 lbs

- D3785-5 = 0.25 lbs

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

Requested By: _____

Design Manager Approval: _____

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
5	D3701-1F	FLOOR DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3702-1	FORWARD DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-1F	AFT DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-3F	AFT CORNER DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-5	AFT CAP	08.04.30	Y	08.05.02	FOR TESTING	
1	D3785-041	ARMREST WELDMENT	08.04.29	N/A	08.05.12	FOR TESTING	
2	D3785-1	TUBE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-3	BRACKET	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-5	FIXTURE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

Requested By: [Signature]

Design Manager Approval: [Signature]

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3781-041	CUSHION ASSEMBLY	08.04.29	N/A	08.05.12	FOR TESTING	
2	D3781-1	SUPPORTING PLATE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
1	D3781-3	CUSHION	08.04.29	N	END OF MAY	GET QUOTE FROM CHESTNUT RIDGE DAN STOW WILL MAKE ONE FOR TESTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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POSITIVE
RECALL

Additional Product

FOR ENGINEERING USE ONLY **PRELIMINARY ISSUE**

Job Number:



PROTOTYPE

Seq. #: Machine Or Operation: Description:

1.0 M304B0625X3000 *M6061T6B0625X0150* 304-BAR-625X3.00



Comment: Qty.: 0.0137 f(s)/Unit Total: 0.0273 f(s)

304-BAR-625X3.00

batch: *106859710-5451B*

6061-T6 Bar. 625 "X 2.5"

8-5-5

103755 P10: 3207
IB 8-5-22

2.0 WATER JET *4 magna* FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3785

Dwg Rev: *PRE-L*

Prog Rev: *PRE-L*

2- Deburr if necessary

den

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-5-5

IB 8-5-22



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 0005108 (K2)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Face mill to finish size as per dwg D3785 7/10/04-05-22

2- 1/4" open hole to finish size as per dwg D3785 7/10/04-05-21

3- 1/4" hole as per dwg D3785

FF 08-05-13

Receiving Report

Date: 7/3/9
Supplier: 83201

Batch No: M103255
Dart P/O: 3207

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☐ No ☒
Waybill Attached: Yes ☐ No ☒
Shipment Complete: Yes ☒ No ☐
QC6 Inspection OK
Work Order

N/A
N/A
N/A
N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061T6B0605X020		36	40	0	0V/2	4

Initials of receiver (if shipment OK) Level 12

Production/Admin: 07/03/13
Date: R/P 3991
Received/Costing:
Initial:

Location

DART AEROSP
1270 ABERDE
HAWKESBURY,
ONTARIO
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

613-632-5200 613-632-1053

DATE	QTY	DESCRIPTION	QTY	DATE
3/11/2007	3	ALUM. 5062-1122-1	3	3/11/2007
	20	AL. FLAT 248 X 1	20	
	20	AL. FLAT 172 X 1	20	
	40	AL. FLAT 148 X 1	40	
	26	ALUM. PLAT 5/8 X	26	
	20	AL. ROUND 3/4	20	
	2	ALUM. 5061-16 080	2	
	1	ENERGETIC SURCHA	1	

DATE RECEIVED:
TIME:

DATE RECEIVED:
TIME:



ALCOA EXTRUSIONS, INC.
33 POTTSVILLE STREET
CRESSONA, PA
17929-0187

Alcoa Extrusions, Inc. a subsidiary of Alcoa Inc

Invoice To Customer

ALCOA EXTRUSIONS, INC.
33 POTTSVILLE STREET
CRESSONA, PA 17929-0187

SALES ORDER: 800170
ALCOA EXTRUSIONS, INC.
33 POTTSVILLE STREET
CRESSONA, PA 17929-0187

Certified Inspection Report

Sales Order Number
4449731

Line No. 1

Customer P/O
N19176-1

BL 993346

Cert Number

AEP1079984

Page

1 of 2

Cert Creation Date

09-JAN-07

Cert Print Date

09-JAN-07

Quantity Shipped	Date Shipped	Item Description
956 LB	09-JAN-07	Extruded Rectangular Bar
BL	Item No.	0.625" THK x 2.500" W RAD
1097760	CU3246382	240,000 IN L
Delivery ID	Item No. Rev	6061 / 10911
1993346	--	VIN M-MHJ
Customer Part No		WIP 1.000 P OY CUS 2.6
V832012		Marking CONTINUUM
		ALUMINUM REV 6

Applicable Specifications, Revisions and Exceptions

COMPOSITION NOTE: The values for 'Others Each' and 'Others Total' have met the limits as shown in this certified inspection report. Remainder is Aluminum.

Legal Statement

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition and had the mechanical properties shown on the face of this certification. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. This certification is not to be reproduced in partial form without prior written approval of our Quality Assurance Dept.

Signature And Title

Dave A. Lukasz

Dave A. Lukasz
Tech/Quality Manager

09-JAN-07

Quantities per Lot / Packages

Package Number	Lot Number	Quantity	UOM	Weight	
				Gross	Net
G12-PK0543769	6194250	26	PCS	964	956

Composition Limits

Alloy	Si		Fe		Cu		Mn		Mg		Cr	
	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
6061	0.40	0.8	--	0.7	0.15	0.40	--	0.15	0.8	1.2	0.04	0.35

Alloy	Zn		Ti		Bi		Pb		Others Each		Others Total	
	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
6061	--	0.25	--	0.15	--	0.05	--	0.05	--	0.05	--	0.15

09:18

450-377-XXXX

ACIER CAMP I

PAGE 08/10



ALCOA EXTRUSIONS, INC.
53 POTTSVILLE STREET
CRESSONA, PA
17929-0187

Certified Inspection Report

Sales Order Number
4449731

Customer P/O
N19176-1

Cert Number	Page
AEPI079984	2 of 2
Cert Creation Date	Cert Print Date
09-JAN-07	09-JAN-07

Composition Results

Heat / Cast / Lot Number	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Bi
5015436	0.7	0.26	0.28	0.05	1.0	0.05	0.04	0.02	-

Heat / Cast / Lot Number	Pb	Others Each	Others Total
5015436	-	-	-

Mechanical Property - Test Limits

Test Type			UTS - L		TYS - L		EL 4B-Long	
UOM			KSI		KSI		PCT	
# of Tests			-		-		-	
Test Temper	Lot Number	# of Tests	Min	Max	Min	Max	Min	Max
T6511	6194250	1	42.1	42.1	38.0	38.0	17.3	17.3

Cert Notes

Products manufactured with a T6511 temper also meet T6 temper requirements.
Yield strength has been determined by the 0.2% offset method
Made in USA

ACCEPTABLE FOR TESTING ONLY.

1308.0606